

# Work Order ID 68154

Thursday, April 07, 2011 8:51:09 AM



Page 1

Item ID: D2957

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Plate

Start Date: 4/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*N*

Date: 11-04-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2957	Rev B								

100

0.00



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks 10.500" long  
1 blank makes 5 parts

0.00

*ank 11/04/15*

10

*0*

110

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per folio FA042  
Deburr

0.00

*B.A 11/04/18*

8

2

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

*B.A 11/04/18*

8

*0*

(PTO 7)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 02957 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 11 Date: 11/05/02  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/05/03 Date: 11/05/03

NCR: 68154		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/18	110	2 parts lifed out of jaws during machining → jaws need to be remachined. cc: tooling failure	<u>11/04/18</u> <u>09/10/18</u>	→ jaws have been remachined D.A. 11/04/18 → scrap and destroy Qty 2 Batch #103019	<u>Y.A.</u> 11/04/18	<u>11/04/20</u>	<u>11/04/20</u>	<u>11/04/20</u>

NOTE: Date & initial all entries

# Work Order ID 68154

Thursday, April 07, 2011 8:51:09 AM



Page 2

Item ID: D2957

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Plate

Start Date: 4/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*aml 11/04/20*

*8*

*0*

150

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

\*\*\*\*\*STOCK IN BASKET CELL\*\*\*\*\*

*SAD 11-04-27*

*8*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/4/28*

*mk*

*11-04-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 07, 2011 8:51:15 AM

Page 1

Work Order ID: 68154



Parent Item: D2957



Parent Item Name: Mounting Plate

Start Date: 4/7/2011

Required Date: 4/13/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C000.08.09 New dwg rev B (mpp 2078) EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X01.25 0		Purchased	No			100	f	15.4000	0.175	1.473684			



6061-T6 Bar .500 x 1.25

Location	Loc Qty	Loc Code
MAT010	15.4	
P103019	8.5	
7872	6.9	

1.75 *an Ruben/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68154
<b>Description: Mounting Plate</b>		<b>Part Number:</b>	D2957
<b>Inspection Dwg: D2957 Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	0.251	✓		Vern	GA-01
0.068	+/-0.010	0.068	✓		H-6	31006
Ø0.323	+/-0.010	Ø0.326	✓		Vern	GA-01
0.250	+/-0.010	0.248	✓		H-6	31006
1.06	+/-0.030	1.063	✓		Vern	GA-01
0.875	+/-0.010	0.875	✓		"	"
0.449	+/-0.010	0.449	✓		H-6	31006
R0.12	+/-0.030	R0.125	✓		R-6	ref.
1.85	+/-0.030	1.851	✓		Vern	GA-01
0.250	+/-0.010	0.247			"	"
0.19	+/-0.030	0.188	✓		"	"
0.125	+/-0.010	0.125	✓		"	"
Ø0.191	+0.008 -0.01	Ø0.192	✓		"	"

<b>Measured by:</b>	G.A.	<b>Audited by:</b>	amb	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11/04/18	<b>Date:</b>	11/04/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	TF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

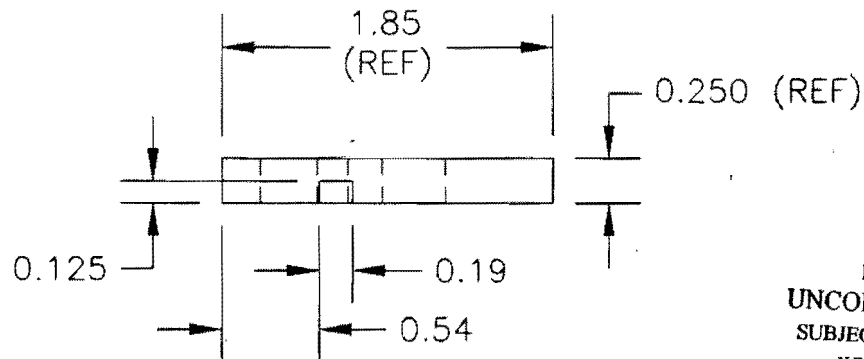
**NOTE:** Date & initial all entries





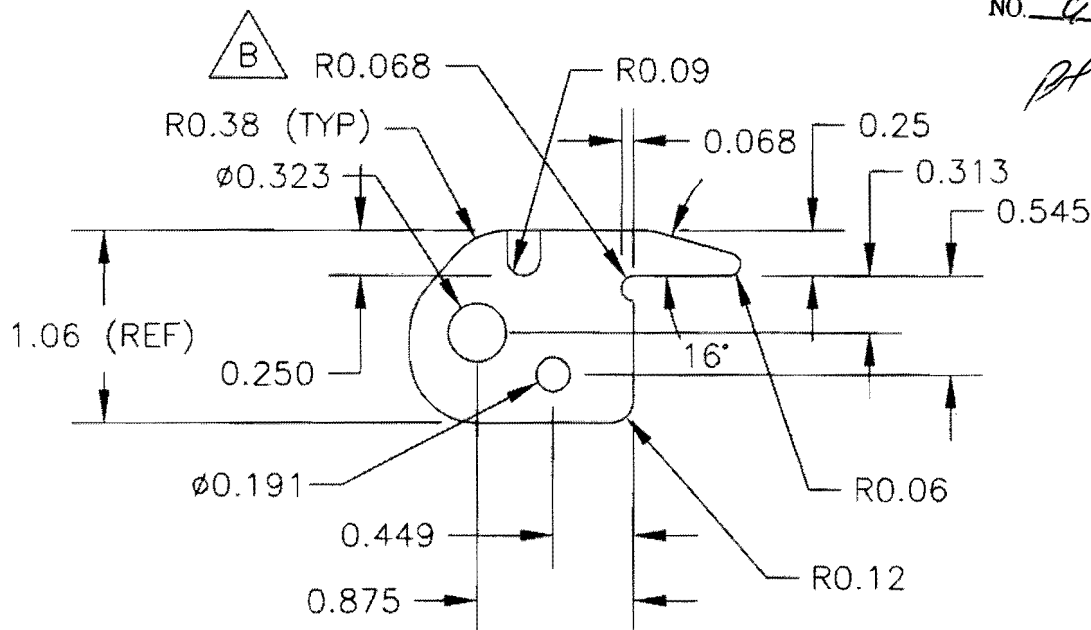
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2957	REV. B SHEET 1 OF 1
DATE 00.07.06	TITLE MOUNTING PLATE		SCALE 1:1
A	00.01.20	NEW ISSUE	
B	00.07.06	MODIFY CORNER DETAIL	

RELEASED  
00.07.10 *[Signature]*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 05154

*PH11-04-7*



MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR  
QQ-A-250/11) 0.250 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL SHARP EDGES 0.010 TO 0.020

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries